

Work Order ID 57458

April 7, 2010 9:58:12 AM



Page 1

Item ID: D412-704-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Assembly (205/212/214/412)

Start Date: 07/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-11-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D412-704-041

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble pedal as per Dwg D412-704-041 ☐ Tighten & Torque Bolts as per
Dwg D412-704-041
10/06/23 (4)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/06/23

(4)

120

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

PC/10/06/23 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
140 Packaging Packaging	Identify as per dwg & Stock Location: <u>191</u> Memo	0.00 0.00							
150 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

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IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
IPP Rev:E 07.05.02 Reformat EC

Start Date: 07/04/2010

Required Date: 16/04/2010

Start Qty: 4.00

Required Qty: 4.00

AN3-10A

Purchased No

100

Each

44.0000

4.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST351

44

111119

44

AN315-4R

Purchased No

100

Each

77.0000

4.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST324

77

17566

77

AN3-6A

Purchased No

120

Each

287.0000

8.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST351

287

113149

85

113288

2

113359

200

EP 06/23
M114330 (42)

EP 06/23

4
EP 06/23 (4)

M113309

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 IPP Rev:E 07.05.02 Reformat EC

Start Qty: 4.00

Required Qty: 4.00

AN4-10A Purchased No 100 Each 92.0000 4.0000
 Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST356 92

111425 42

113422 50

AN4-12A Purchased No 100 Each 258.0000 8.0000
 Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST357 258

112314 258

AN4-13A Purchased No 100 Each 47.0000 4.0000
 Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST357 47

114181 40

4828 7

Ep 5.0/06/23

4
Ep 5.0/06/23

8
Ep 5.0/06/23
 M114941 (40)

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 IPP Rev:E 07.05.02 Reformat EC

Start Date: 07/04/2010

Required Date: 16/04/2010

Start Qty: 4.00

Required Qty: 4.00

X AN960JD10 051017 NAS1149D03631 Purchased No

100

Each

0.0000

20.0000



Washer

AN960JD10L 47

Purchased No

120

Each

4,691.000

16.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

4691

110985

4691

Each

0.0000

44.0000

X AN960JD16 051017 NAS1149D04631 M115000 Purchased No

(44x)

100



Washer

AN960JD16L

Purchased No

100

Each

483.0000

12.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST346

483

110153

483

M116985

Ep 5/10/06/23

Ep 5/10/06/23

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 07/04/2010

Required Date: 16/04/2010

Start Qty: 4.00

Required Qty: 4.00

2 D3204-041 Manufactured No 100 Each 2.0000 4.0000
 Release Pedal Assembly

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST197	2	
	55336	2	

D3205-1 Manufactured No 100 Each 14.0000 4.0000
 Pedal Bracket

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST197	14	
	55338	4	
	55731	10	

D3205-3 Manufactured No 100 Each 16.0000 4.0000
 Back Plate

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST197	16	
	47491	16	

Handwritten signatures and dates:
 B57520 (42) 5/10/06/23
 4 5/10/06/23
 4 5/10/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 IPP Rev:E 07.05.02 Reformat EC

Start Date: 07/04/2010

Required Date: 16/04/2010

Start Qty: 4.00

Required Qty: 4.00

D3206-1

Manufactured No

100

Each

19.0000

4.0000



Pedal Arm

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST197

19

47492

4

55732

15

D3209-041

Manufactured No

100

Each

3.0000

4.0000



Bracket Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST197

3

55337

3

MS21042L3

Purchased No

120 100

Each

1,355.000

4.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

1355

113537

371

113644

984



EP 50/06/23



EP 50/06/23
B57521 (100)



EP 10/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP Rev:E 07.05.02 Reformat EC

Start Date: 07/04/2010

Required Date: 16/04/2010

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased No

~~100~~ 160

Each

1,355.000 8.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

1355

113537

371

113644

984

MS21042L4

Purchased No

100

Each

1,590.000 20.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST139

2

111827

2

Main Warehouse

ST300

1588

113422

580

114108

1000

9063

8

April 7, 2010 9:58:16 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Qty: 4.00

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IPP Rev:C 06.03.08 Re-format EC

IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM

IPP Rev:E 07.05.02 Reformat EC

MS24694-S102

Purchased

No

100

Each

16.0000

4.0000



Screw



EB 10/06/23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST289A

16

113644

16

MS9519-10

Purchased

No

100

Each

46.0000

4.0000



Bolt



4
EB 10/06/23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST297

46

100290

46

4

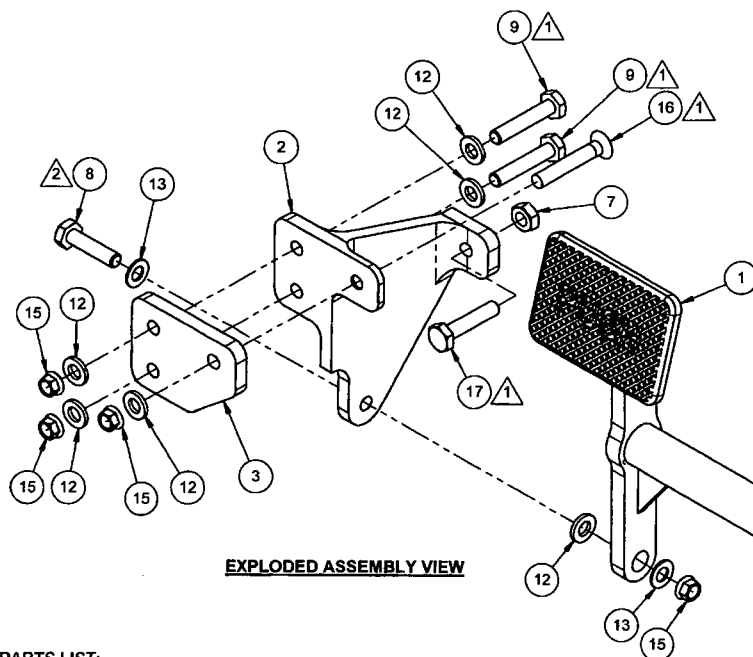
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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EXPLODED ASSEMBLY VIEW

PARTS LIST:

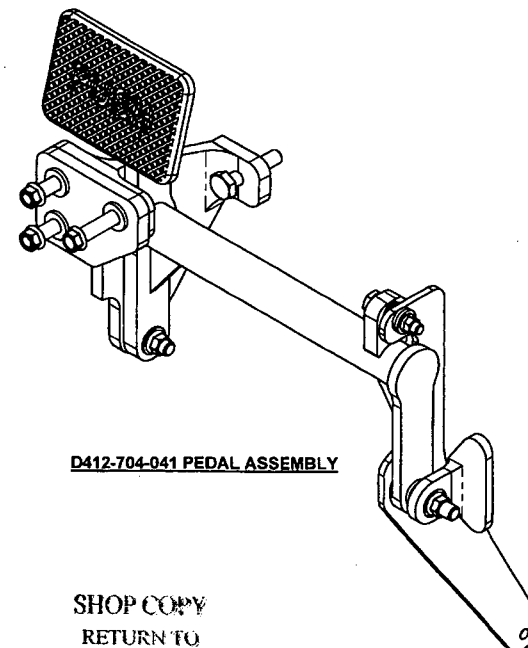
ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

Stone



D412-704-041 PEDAL ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *57455*
B-10-9-07

RELEASED

07.01.30

A	07.01.23	NEW ISSUE	
REV	DATE	DESCRIPTION	
DESIGN	CB	DART AEROSPACE LTD	
	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CE	DRAWING NO.	REV. A
		D412-704-041	SHEET 1 OF 1
DATE	07.01.23	TITLE	SCALE
		PEDAL ASSEMBLY	1:2

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